

Work Order ID 65091

Thursday, January 06, 2011 10:40:44 AM



Page 1

Item ID: D2857-2

Accept



Setup Start



Revision ID:

Item Name: Hinge Bracket

Stop



Start Date: 1/6/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: H Date: 11-01-11 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2857	Rev <u>BC</u> <u>11-01-11</u>

100	BAND SAW	0.00							
	Bandsaw								
Jeaspa Bandsaw	Memo Cut blanks 4.425"	0.00		<u>011/03/07</u>		<u>10</u>	<u>1</u>		

110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	Memo 1-Machine per folio FA940 FOLIO REV: <u>4A</u> DWG REV: <u>C</u> 2-Deburr any rough edges	0.00		<u>011/03/08</u>		<u>10</u>	<u>1</u>		<u>PTG</u>

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00		<u>011/03/08</u>		<u>10</u>	<u>1</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2857-2 PAR #: _____ Fault Category: leveling NCR: Yes No DQA: [Signature] Date: 11/03/09
 Resolution: SCVAP Disposition: SCVAP QA: N/C Closed: [Signature] Date: 11/03/17

NCR: <u>65091</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/03/08</u>	<u>110</u>	<u>1 parts scrap, one section of .125 thick are too thin</u> <u>R.C. origine, mist clarity on the folio.</u>	<u>[Signature]</u>	<u>scrap and destroy</u> <u>replace</u> <u>Qty 1 Batch H116623</u>	<u>[Signature]</u> <u>11/03/09</u>	<u>[Signature]</u> <u>11/03/09</u>	<u>[Signature]</u>	<u>11/03/09</u>

NOTE: Date & initial all entries

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Page 2

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Item Name: Hinge Bracket

Start Date: 1/6/2011 Start Qty: 10.00

Required Date: 1/13/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11/03/09					
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							10 BR 11-3-9
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							18 6 11 1/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65091

Thursday, January 06, 2011 10:40:44 AM



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Item ID:	D2857-2	Accept		Setup	Start	
Revision ID:						
Item Name:	Hinge Bracket				Stop	
Start Date:	1/6/2011	Start Qty:	10.00			
Required Date:	1/13/2011	Req'd Qty:	10.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 115951</i> Memo START TIME: <i>3:35</i> <i>3:20</i> FINISH TIME: <i>4:05</i>	0.00 0.00				<i>10</i>		<i>BL 11-3-14</i>	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>10</i>	<i>0</i>	<i>11/03/15</i>	
180 Packaging Packaging	Identify as per dwg & Stock Location <i>24</i> Memo	0.00 0.00				<i>11/3/15</i>		<i>105</i>	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries


Work Order ID 65091

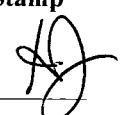
Thursday, January 06, 2011 10:40:44 AM

Page 4

Item ID: D2857-2 Accept  Setup Start 
Revision ID:
Item Name: Hinge Bracket Stop 
Start Date: 1/6/2011 Start Qty: 10.00  Cust Item ID:
Required Date: 1/13/2011 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

11/3/16 
MF
11-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, January 06, 2011 10:40:48 AM

Page 1

Work Order ID: 65091



Parent Item: D2857-2



Parent Item Name: Hinge Bracket

Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP ☐ C ☐ 00.06.22 ☐ Removed P/O for powder coat ☐ EC ☐
IPP ☐ D ☐ 06.03.30 ☐ Added level 8 ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	10.3055	0.37	3.894737			



6061-T6 Bar 2.00 x 1.25

Location	Loc Qty	Loc Code
MAT	10.3055	
114507	7.6555	
114899	2.65	

M116623 X 3.894

only 11/03/07

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	45091
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.303	—		Ure	ML-7
4.000	+/-0.010	4.000	—		"	"
0.340	+/-0.010	.341	—		"	"
1.110	+/-0.005	1.110	—		"	"
1.790	+/-0.010	1.795	—		"	"
1.320	+/-0.005	1.319	—		"	"
2.000	+/-0.010	2.002	—		"	"
0.340	+/-0.010	.341	—		"	"
0.447	+/-0.010	.447	—		"	"
Ø0.171	+0.005/-0.000	Ø.173	—		"	"
0.147	+/-0.010	.147	—		"	"
0.376	+/-0.010	.379	—		"	"
0.126	+/-0.010	.124	—		"	"
0.063	+/-0.010	.060	—		"	"
Ø0.166	+0.005/-0.000	Ø.167	—		"	"
0.911	+/-0.010	.911	—		"	"
0.600	+/-0.010	.599	—		"	"
0.125	+/-0.010	.123	—		"	"
0.150	+/-0.010	.146	—		"	"

Measured by:	amk	Audited by:	SL	Prototype Approval:	N/A
Date:	11/03/08	Date:	11/03/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

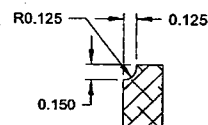
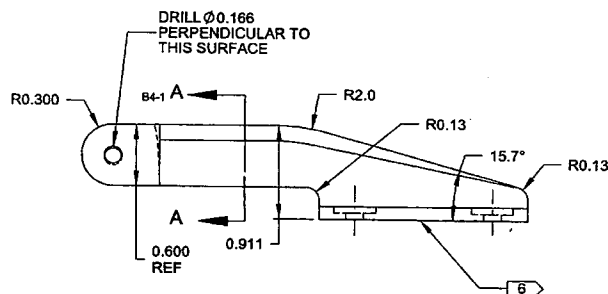
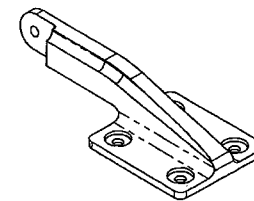
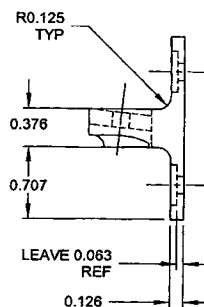
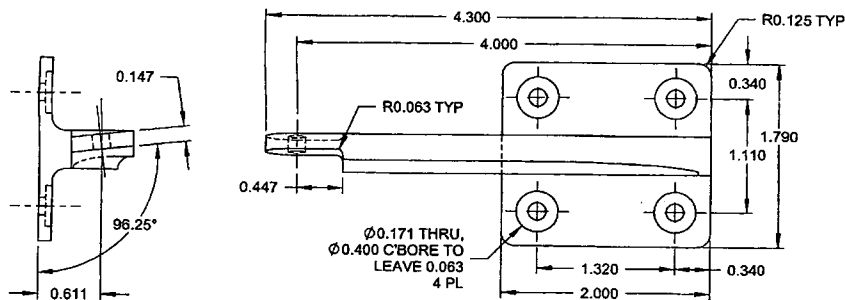
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NOTE: Date & initial all entries



B7-1 SECTION A-A

D2857-1 HINGE BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. U5081

PS 11-01-6

RELEASED
2010-11-26

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1(FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

C	REFORMAT DWG. IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1), REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	08.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D2857	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	HINGE BRACKET	NTS
DATE	10.09.13	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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